



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1701
Job Sheet 184645

Part No: 647.1701

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Job Created: 10/15/18

Due Date: 10/29/18

Type: SOLD

Ship Via:

Job Qty: 2 ea

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS IPP REV:B 18.03.01 REVISE BOM AS PER
DWG DD VERF:DP

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/29/18	10/29/18	0.00	0.00	Start Up Stores/Pkg-1		OCT 17 2018 6 DAS
110	Packaging	2 pcs	10/29/18	10/29/18	0.00	0.00	Packaging1-1		OCT 17 2018 9-89 6 DAS
120	Small Fab	2 pcs	10/29/18	10/29/18	0.00	0.82	Small Fab-1		OCT 25 2018 68 DAS
130	QC	2 pcs	10/29/18	10/29/18	0.00	0.00	QC5		OCT 18-10-2018 68 DAS
190	Small Fab	2 pcs	10/29/18	10/29/18	0.00	0.82	Small Fab-1		OCT 26 2018 68 DAS
200	QC	2 pcs	10/29/18	10/29/18	0.00	0.00	QC5		OCT 30 2018 9-89 6 DAS
210	Packaging	2 pcs	10/29/18	10/29/18	0.00	0.00	Packaging3-1		OCT 30 2018 9-89 6 DAS
220	QC21-SA	2 Ea	10/29/18	10/29/18	0.00	0.00	QC21		OCT 30 2018 9-89 6 DAS

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine 6- Re-assemble as per dwg ***

***TOUCH UP RIVET WITH PRIMER *** PRIMER BATCH: 5094268 ***

190 - ASSEMBLE AS PER DWG

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712	Gusset	2 Ea (1 ea)	90-Start up Operation	5052140
CR3213-4-4	Rivet, Cherry	44 Ea (22 ea)	90-Start up Operation	5049832
MS27039-1-14	Screw	2 Ea (1 ea)	90-Start up Operation	5124326-4
NAS1149F0332P	Washer	4 Ea (2 ea)	90-Start up Operation	5009491
647.1710	Plate	2 Ea (1 ea)	90-Start up Operation	5022167
647.1711	Plate	2 Ea (1 ea)	90-Start up Operation	5027168X1 5063 356X1
647.1713	Spacer	2 Ea (1 ea)	190-Small Fab	5031908
MS21042-3	Nut	2 Ea (1 ea)	190-Small Fab	5108582

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.1710	2	13	0
	647.1711	2	9	0
	647.1712	2	43	0
	CR3213-4-4	44	687	0
	MS27039-1-14	2	397	0
	NAS1149F0332P	4	2,735	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
Completed By _____ / Supervisor _____ Verification _____ Coordinator _____ al _____	

Container No: S119218

Part: 647.1701

Job No: 184645

Serial No/Batch: S119218

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____

Date: 10/17/18

Dart Aerospace Ltd.
1270 Aberdeen Street, KT
Hawkesbury, ON K6A 1K7
CANADA 613 832-5500
Tel: sales@dartaero.com
Email: sales@dartaero.com
www.dartaerospace.com

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

190-Small Fab

647.1713
MS21042-3

2
2

44
406

0
0

Part Specifications

Specifications could not be found.

Plex 10/15/18 1:50 PM Dart.lajeunesse.marie

647.1701
S119218
REV.E

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					